

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 134131

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134131

Page 2

Item ID: D350-740-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aircraft Disabling Device

Start Date: 7/03/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/06/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Packaging

Memo

0.00

PACKAGING RESOURCE #1 Identify and pack for shipping as
per PPP D350-740-011 Location Sold PPP
Rev: _____ Record Key Numbers For The Following: D3371-
041 D3372-041 _____

DAS
02
9-89

JUL 07 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ

JUL 07 2015

ME
(5-7-7)

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Friday, July 03, 2015 9:51:25 AM

Work Order ID: 134131

134131

Parent Item: D350-740-011

D350-740-011

Parent Item Name: Aircraft Disabling Device

Start Date: 7/03/15**Required Date:** 7/06/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E Re-Format 06-01-13 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3372-041		Manufactured	No			110	Each	1.0000	1	1			
D3372-041 Collective Lock AS330													
DAS 02 9-89													
Location Loc Qty Loc Code													
ST500 1													
132419 1													
D3371-041		Manufactured	No			120	Each	0.0000	1	1			
D3371-041 Tail Rotor Pedal Lock													
DAS 02 9-89													
103 109													

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

- 3.3.3 Place the D3384-043 Collective Sock over the collective control stick as shown in Figure 2.
- 3.3.4 Unlock/open the collective lock and secure around the aircraft collective control base by aligning the shaft of the lock device with the hole in the collective base as shown in Figure 2. Engage cam and lock D3372-051/ D3400-051 Collective Lock Assembly with the provided key. Ensure that the device is locked and will not open.

3.4 D3372-041/ D3400-041 COLLECTIVE DISABLING KIT REMOVAL

- 3.4.1 Unlock D3372-051/ D3400-051 Collective Lock Assembly from the collective control base using the provided key. Open the lock, and remove from the collective control base.
- 3.4.2 Remove D3384-043 Collective Sock from the collective control stick.

4.0 PARTS LIST

-011	-013	Part Number	Description
X		D350-740-011	DUAL DISABLING KIT
	X	D355-740-013	DUAL DISABLING KIT
1	1	D3371-041	TAIL ROTOR PEDAL DISABLING KIT
1	1	D3371-051	* PEDAL LOCK ASSEMBLY
1	1	D3384-045	* CYCLIC SOCK
1	1	HX-81	* 1/4" -20 SOCKET HEAD CAP SCREW
2	2	AN960-416	* WASHER
1	1	D3373-7K	*** KEY, REPLACEMENT
1		D3372-041	COLLECTIVE DISABLING KIT
1		D3372-051	* COLLECTIVE LOCK ASSEMBLY
1		D3384-043	** COLLECTIVE SOCK
1		HX-81	** 1/4" -20 SOCKET HEAD CAP SCREW
2		AN960-416	** WASHER
1		D3373-1K	*** KEY, REPLACEMENT
	1	D3400-041	COLLECTIVE DISABLING KIT
	1	D3400-051	* COLLECTIVE LOCK ASSEMBLY
	1	D3384-043	** COLLECTIVE SOCK
	1	HX-81	** 1/4" -20 SOCKET HEAD CAP SCREW
	2	AN960-416	** WASHER
	1	D3373-1K	*** KEY, REPLACEMENT

* shown for reference only, part is included in D3371-041 assembly above

** shown for reference only, part is included in D3372-041/ D3400-041 assembly above

*** shown for reference only, p/n for ordering replacement keys